

Date: Tuesday, 11/6/2007 1:12:25 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	6" MIRROR
Job Number :	35536		
Estimate Number :	10101		
P.O. Number :	N/A	Part Number :	D2011101
This Issue :	11/6/2007	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2011 REV. F
First Issue :	N/A	Project Number :	N/A
Previous Run :	34886	Drawing Revision :	F
		Material :	N/A
Written By :		Due Date :	11/20/2007
Checked & Approved By :		Qty:	50 Um: Each
Comment :	Est: J 04.09.15 Added Steps 5-7 KJ/JLM		
	Est: K 05.12.15 chg black sikaflex for white EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 4999
 Purchase Grote Mirror P/N: 28043
 Possible supplier: UAP/NAPA
 Material release note required

C/L 7/11/07

(50)

2.0 28043 MIRROR 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 Mirror 6"

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage
 Ensure Material Release Note is attached

7-11-12

SQ

(50x)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 D30141 Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Locknut

Pick:

Qty Part Number Description Batch

1 D3014-1 Lock nut B25021

x49 PTO

ml 07/11/14

✓ ml 07/11/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2011-101 PAR #: N/A Fault Category: Prod / Eng Ass ^{NCR # Small} NCR: Yes No DQA: 12 Date: 07/11/22
 QA: N/C Closed: 12 Date: 02.11.23

NCR: <u>35536</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/14	49	one of the mirrors is no good the seal wasn't install well	<u>[Signature]</u> 05/11/22	Scrap mirror	<u>ml</u> 07/10/14	<u>[Signature]</u> 07/11/20	<u>[Signature]</u> 05/11/22	<u>[Signature]</u> 07/11/20

NOTE: Date & initial all entries

Date: Tuesday, 11/6/2007 1:12:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 6" MIRROR

Job Number: 35536

Part Number: D2011101

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

AN960JD416L

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~50.0000~~ Each(s) **48 49**

Washer

Pick:

Qty Part Number Description

Batch

1 AN960JD416L Washer

M105408

✓ ml 07/11/14

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Discard Hardware & Install new hardware loosely

2- Drill mirror using drill Jig DT8704 as per Dwg D2011

3- Inject 3ml of Sikaflex -291/-241 adhesive per hole.

Qty Part Number

Description

Batch

9ml N/A

Sikaflex-291/-241

M105488

Expiry date

07/2008

Start: **07/11/14** Time: **3:30**

Finish: **07/11/20** Time: **12:00 noon**

ml 07/11/15

(x48)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4- Test assembly to 50lbs pull test after 24 hours

07/11/20 (x48)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: **ST 227**

sf/83 over

AS 07/11/21

(x48)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/20

(48)

Job Completion

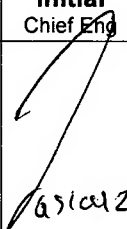
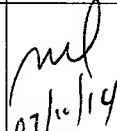
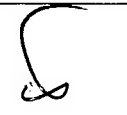

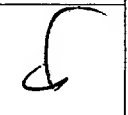


U 07.11.21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

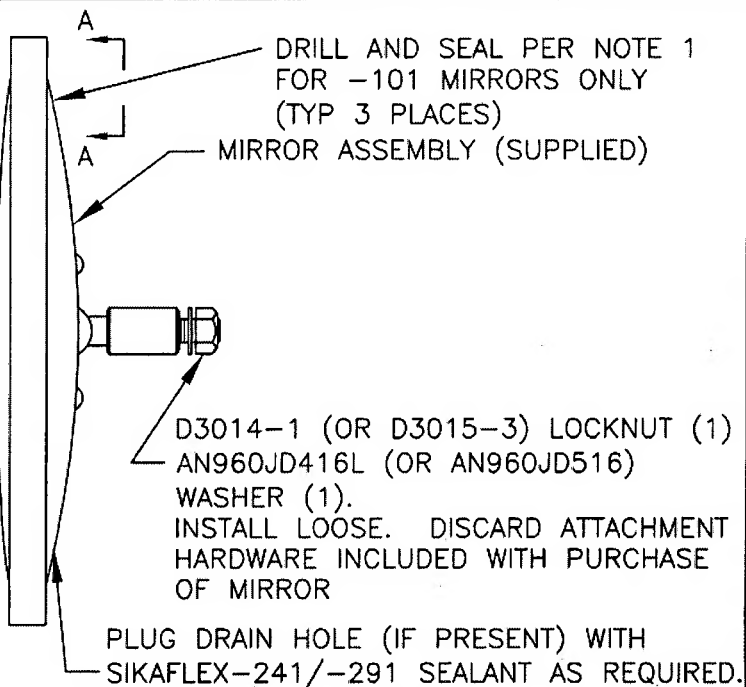
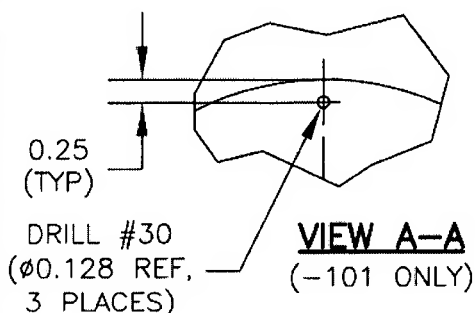
Part No: D2011-101 PAR #: NA Fault Category: Prod / Prod Ass' made 5/22/11 NCR: Yes No DQA: D Date: 07/11/22
 QA: N/C Closed: 7/11/23 Date: 07.11.23

NCR: <u>35532</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/14	7	Brake 1 mirror when drilling	 05/10/22	Scrap replace No	 07/11/14	 07/11/20	 05/10/22	 07/11/20

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2011	REV. F SHEET 1 OF 1
DATE 04.09.10		TITLE MIRROR ASSEMBLY	SCALE 1:2
-	90.03.31	NEW ISSUE	
A	90.06.15	DWG No. WAS DSP1011, ADDED -103	
B	98.04.09	SIKAFLEX 241 ADDED	
C	99.06.01	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN	
D	01.04.23	NEW 6" MIRROR, ADD NUT, RMV STUD	
E	01.05.08	NEW 8" MIRROR	
F	04.09.10	ADD HOLES FOR SEALANT ON -101	



RELEASED
04.09.10

QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

NOTES:

- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35536

Copyright © 1990 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



WILKESBURY AUTO PARTS INC 5580GST#:

861597896RT0001

4 MAIN STREET WEST

WILKESBURY, ONT. K6A 2J2

TEL: 632-8575 FAX: 632-1539

DANGEROUS GOODS PERMIT
EXPIRY DATE:EMERGENCY TELEPHONE NUMBER 24 HOURS
CANUTEC 613-996-6666

PO #	SOLD TO	DATE	TIME	STORE #	EMP #	INVOICE NO.
	DART AEROSPACE LTD 1230 ABERDEEN STREET WILKESBURY, ONTARIO K6A 2K7	11/12/07	14:44	060004074	31	180544
		PURCHASE ORDER #		ATTENTION		
		4999		4999.		
		TAX EXEMPTION: 6122-5207				
		TERMS: NET 30 DAYS		CHARGE SALE		
		DELIVERY:				

PART NUMBER	LN	DESCRIPTION	QUANTITY	PRICE	NET	TOTAL
	GRD	GRDTE	50.00	41.140	16.820	841.00 T150

APPROVED BY _____

Subtotal

841.00

APPROVED BY _____

Tax 6% GST ONLY

50.46

Tax 0%

0.00

SIGNATURE

TOTAL ----> CHARGE SALE 891.46

ALL GOODS RETURNED MUST BE ACCOMPANIED BY THIS INVOICE